

Date: Friday, 06/06/2008 11:01:46 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: X-TUBE EXTRUSION
Job Number	: 39735		
Estimate Number	: 11108		
P.O. Number	:	Part Number	: D6008180
This Issue	: 06/06/2008 S.O. No. :	Drawing Number	: D6008 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : PURCHASED PARTS	Drawing Revision	: A
Previous Run	: 38341	Material	:
Written By	:	Due Date	: 13/09/2008 Qty: 20 Um: Each
Checked & Approved By	:		
Comment	: Est Rev:C 04.06.15 Added tolerance to Step 2 KJ/JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 6521

C208/06/106 (20)

a) Order as per Dwg D6008

b) Material: 3.250 x 0.438 wall 7075-T6/T6511 (WW-T-700/7 or QQ-A-225/9 or QQ-A-200/11) seamless aluminum tube

c) Minimum ultimate tensile strength = 77 ksi

d) Minimum tensile yield strength = 66 ksi

e) Tolerance are per ASTM B210 (see details on Dwg D6008)

f) Material certification required

2.0	D6008180P	Crosstube extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit : Total : 20.0000 Each(s)

Crosstube extrusion

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive &amp; Inspect For Transit Damage

Ensure material certification is attached

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Ensure Material certification comply to Dwg D6005

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 06/06/2008 11:01:46 AM  
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Drawing Name: X-TUBE EXTRUSION

Job Number: 39735

Part Number: D6008180

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*Handwritten signature*

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *Back Hall*

*RT 08-09-17*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08/09/18*

Job Completion



*h 08.09.18*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

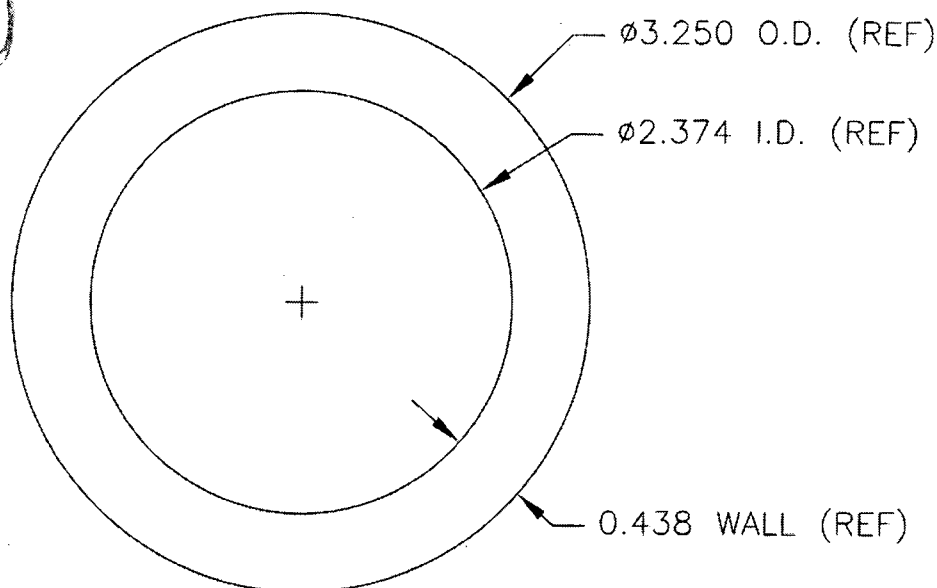
NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D6008	REV. A SHEET 1 OF 1
DATE 00.11.17		TITLE CROSSTUBE MATERIAL	SCALE 1:1
A	00.11.17	NEW ISSUE	

## SPECIFICATION CONTROL DRAWING

RELEASED  
00.11.24 *[Signature]*



### NOTES

- 1) D6008-XXX CROSSTUBE  
LENGTH

WHERE XXX IS LENGTH IN INCHES  
EG. 180" LONG TUBE: D6008-180

*10/3/98*

- 2) MATERIAL: 3.250 OD x 0.438 WALL 7075-T6/T6511 (WW-T-700/7 OR QQ-A-225/9 OR QQ-A-200/11) SEAMLESS ALUMINUM TUBE.  
MINIMUM ULTIMATE TENSILE STRENGTH = 77 ksi  
MINIMUM YIELD TENSILE STRENGTH = 66 ksi
- 3) TOLERANCES ARE PER ASTM B210 AS FOLLOWS:  
O.D.:  $\pm 0.008$  MEAN ( $\pm 0.016$  INCLUDING OVALITY)  
WALL:  $\pm 0.020$  MEAN ( $\pm 0.044$  INCLUDING ECCENTRICITY)  
LENGTH: XXX  $+0.125/-0.000$   
STRAIGHTNESS: 0.010" DEVIATION / 12" LENGTH
- 4) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 5) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Abnahmeprüfzeugnis 3.1 - EN 10204:2004

Inspection Certificate 3.1 - EN 10204:2004 / Certificat de Reception 3.1 - EN 10204:2004

**Kunde:** Dart Aerospace Ltd.  
**Client:** 1270 Aberdeen Street  
 K6A1K7 Hawkesbury, ON Canada

**Zeugnisnummer:** 1285/08  
**Cert No. / No. du certificat:**  
**Bestellnummer:** PO 00006521  
**Order No. / No. de commande**  
**Auftrag:** 29893/2  
**Our Reference/Notre Reference:**

**Produkt:** Rohre nahtlos gepresst  
**Product / Produit:** Tubes seamless extruded  
**Spezifikation:** -; AMS - QQ - A - 200/11E; -; -; Spezifikation Dart Aerospace D6008  
**Specification:**

**Werkstoff:** 7075  
**Alloy/Alliage:** **Zustand:** T 6511  
**Temper/État:**

**Abmessung:** 3,250 INCH x 2,374 INCH x 0,438 INCH x 180,000 INCH  
**Size / Dimension:** D6008-180 3.250 x 0.438 x 180

**Kennzeichnung:** ALUnna - Cert No. 1285/08 - 7075 - T6511 - Cast No. 81742 - AMS - QQ - A - 200/11 - 3.250" OD X 0.438" Wall -  
**Marking/Marquage:** Heat Lot No. 1837 - ALUnna Order Conf. 29893/2-1 - P.O.00006521

**Lieferung:** Stück kg  
**Delivered Material / Matériel délivré:** 15 484,00

## 1. Chemische Analyse Chemical Analysis / analyse chimique

	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Pb	Zr	Bi	Sn	As
Charge/ min.			1,2		2,1	0,18	5,1						
Cast No. max.	0,40	0,50	2,0	0,30	2,9	0,28	6,1	0,20					
81742	0,07	0,13	1,38	0,04	2,45	0,19	5,73	0,04	0,01	0,03	0,01	0,01	0,01

## 2. Mechanische Eigenschaften Mechanical Properties / Valeurs Mécaniques

Anforderungen Requirements	tensile (Rm) ksi	yield (Rp0,2) ksi	elongation 2" %	elongation A %	Hardness HB	Heat Lot No.
min.	77,0	66,0				
max.						
1	87,000	81,490	8,0		158	1837 - 15 pcs.
2	86,420	79,895	8,0		157	

RMS: outside 25 - max. 6,62 µ"

**Ergebnis der Prüfungen:** Es wird bestätigt, daß die Lieferung geprüft wurde und den Vereinbarungen bei der Bestellannahme entspricht

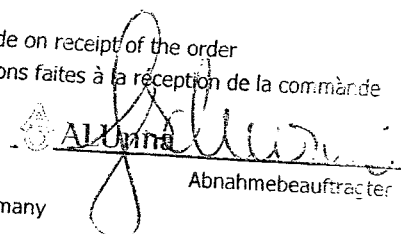
**Test results:** We confirm that the delivery has been tested and applies to the agreements made on receipt of the order  
**Resultats:** Nous confirmons que la livraison a été contrôlée et correspond avec les conventions faites à la réception de la commande

21.08.2008 / Duda



Certified acc. DIN EN ISO 9001:2000 and DIN EN 9100:2003  
 valid until 2010-11-11  
 Cert.-Req. No.: 001959 QM; 001959 ASH

Aluminiumwerk Unna AG, Uelzener Weg 36, 59425 Unna, Germany

  
 Abnahmebeauftragter

PO. 00006521

29893/2

08.21.08

Dart Aerospace PO. 00006521

Made in Germany

Dest.: Hawkesbury Ont. Canada

Boxdimension

[illegible]

8/10/11



**MEDITERRANEAN SHIPPING COMPANY (CANADA) Inc**

360, St. Jacques Street, Suite 900, Montreal  
Phone: +1 514 844 3711 Fax: +1 514 844 4272

Date : 9/15/2008  
Time : 9:12:01AM

**Delivery Order**

TO THE ATTENTION OF :

**TRANSPHEL**

205 CHEMIN DU TREMBLAY

Deliver Container To:	DART AEROSPACE 1270 ABERDEEN ST. Hawkesbury, ON K6A 1K7	Consignee:	TRANSWORLD SHIPPING USA INC.
Contact:	LINDA LACELLE	Drop Off EMPTY At:	
Telephone:	613-632-9577	Scheduled Appointment:	
Fax:		TOFC / COFC:	COFC
		Live Unload:	Yes
		Comments:	
Pick Up At:	Montreal, QC - (.) - TERMONT	PLEASE CALL BEFORE DELIVERY	
Vessel / Voyage:	MSC SERENA / 56A		
Port Of Load:	Bremerhaven, HB, Germany		
Port Of Discharge:	Montreal, QC		

*Please pickup the following container(s):*

CONTAINER TYPE	CONTAINER NUMBER SEAL NUMBER LAST FREE DATE	B/L NUMBER SHIPPER REFERENCE PICK UP NUMBER	WEIGHT	NUMBER of PACKAGES COMMODITY HAZARDOUS INFORMATION	PACKAGE TYPE
40' High Cube	MSCU7564400 W219833	MSCUHB332602 43593723	5,629 kgs.	9 BOXES ALU TUBES HS CODE: 760820811 FREIGHT + ONCARRIAGE PREPAID WAYBILL STRAIGHT CONSIGNMENT AUTOMATIC CARGORELEASE ACI INFORMATION: ACI SUB- MITTED AND PROCESSED BY TRANSWORLD SHIPPING UNDER CBSA CODE:8U22106080573500 <i>Non-Hazardous</i>	Box(es)

Total Weight : 5,629 kgs.

**If you have any questions, please call Brahim Bakri at +1 514 844 3711**

D - 178031

Date 09/15/2008 Facturé A / Billed to MSC S/S Stemship co LTD

Tracteur Tractor	Chassis Remorque / Trailer	Chauffeur Driver	Date de livraison date of delivery	Heure de livraison Time of delivery
24304	52480/227	ROBERT CHRISTIAN	09/16/2008	8:00

Full ☒ X Empty ☐ F/B ☐ Foile ☐ Temp ☐

Expéditeur / Shipper	Disponible à / Available at	Date & heure de ramassage / Date & time pickup
MSC 360 St-Jacques suite 900 MONTREAL, PQ CA H2Y 3X1	TERMONT TER001	09/15/2008
	Booking	Bateau & voy / Vessel & voy
	MSCUHB332602	MSC SERENA 56A

1er Consignataire / 1st Consignee	Conteneur / Container #	Taille / size
DART AEROSPACE 1270 ABERDEEN STREET HAWKESBURY, ON	MSCU7564400	40 HC
	# de Sceau / Seal #	Poids / Weight
	319833	12409

2e Consignataire / 2nd Consignee	# Conteneur / Container #	Taille / Size
TRANSTERM 7600 NOTRE DAME OUEST MONTREAL, PQ H4C 3K4 514-368-1482		
	Port de / of destination	P/U Ville

Traverse douanière et courtier / Border crossing and broker	Heure d'arrivée / Time of Arrival	Heure de départ / Time of departure
	2:30	

Remarque / Remarks
P/U# 43593723

Matières dangereuses / Hazardous materials				
UN #		P.G. #		CLASS UN / GHS

NOTE AU CLIENT / NOTE TO CUSTOMER  
ASSUREZ-VOUS QUE LE SCEAU EST INTACT À LA LIVRAISON / ENSURE SEAL IS INTACT AT TIME OF DELIVERY  
AUCUNE RÉCLAMATION NE SERA ACCEPTÉE SANS AVIS AU MOMENT DE LA LIVRAISON  
NO CLAIM WILL BE ACCEPTED UNLESS REPORTED AT TIME OF DELIVERY

Exceptions :

Imprimez client / print customer	Signature
Imprimez chauffeur / print driver	Signature
CHRISTIAN ROBERT	Christian Robert

TOUT TEMPS D'ATTENTE CHEZ CE CLIENT DEVRA ÊTRE SIGNÉ PAR LE CLIENT "TIME IN" ET "TIME OUT" OU VOUS NE SEREZ PAS PAYÉ. VOUS DEVEZ AUSSI EN TOUT TEMPS, RAPPORTER LA FORMULE DU CLIENT (FEUILLE DE DÉTAILS DU VOYAGE 8,5 X 11") PREUVE DE RÉCEPTION (SIGNATURE OU ESTAMPE)

COPIE DU CHAUFFEUR / DRIVER'S COPY